

Date: Wednesday, 25/02/2009 2:26:52 PM
 User: Julie Dawson

Split for qty 6 ch-2 wro. Rush Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG ASSEMBLY
 Job Number : 46071-1
 Estimate Number : 10911
 P.O. Number :
 This Issue : 25/02/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D3405041
 First Issue : 11 Type : LARGE FAB ASSY Drawing Number : D3405 REV B
 Previous Run : 05052 Drawing Revision : B
 Written By : Due Date : 04/03/2009 Qty: 20 Um: Each
 Checked & Approved By : JUD 09.02.25
 Comment : Est A 05.09.01 New issue KJ/JLM
 Est B 09.01.28 rev.B drawing EC verified by:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S11GA 304/316 0.125 Sheet



Comment: Qty.: 0.1617 sf(s)/Unit Total : 3.2340 sf(s)
 304/316 .125 Sheet
 (M304S11GA)
 Batch: 109358 HB 9-2-26

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3405
 Dwg Rev: B
 Prog Rev: B HB 9-2-26

2-Deburr if necessary HB 9-2-26

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 9-2-26

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK


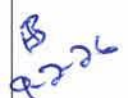

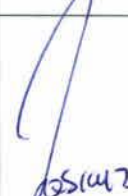
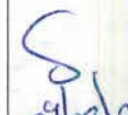

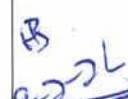



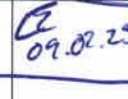

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Deburr x15
 Form using DT8204 as per Dwg D3405

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3405-041 PAR #: N/A Fault Category: Production Coordinator NCR: Yes No DQA: D Date: 09/03/16
 Resolution: Scrap Documentation revised Disposition: Scrap QA: N/C Closed: D Date: 09/03/16

NCR: <u>40071</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/2/26	# 20	All 30 parts are ^{0.160"} 0.160" too short in length. 7.841" Also the hole to hole is cut too short.		Scrap and Destroy Qty x30	 09/02/26	 09/02/26		 09/02/26
		R.C. Program not up to date in charge and operator measured off FAT sheet (later) not doing.		And Replne m# <u>109358</u> Issue new DPK	 09/02/26	 09/02/26		 09/02/26
				= Re program	 09/02/25	 09/02/26		

NOTE: Date & initial all entries

Date: Wednesday, 25/02/2009 2:26:52 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 46071

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.03.10

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

GHW Lug

Pick:

Qty Part number

Description

Batch

1 D3404-1

Lug

A/R

SS Rod

045372
M 9676

Most current Rev. C Lug.

EL 9-3-12

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-041

Q 9-3-12

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Cpl 09.03.12

(x24)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.03.12 (24)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 110939

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:45
400°
13:15

BR 09-03-12

(24)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-13 (x24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/02/2009 2:26:52 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 46071

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 474

8809/03/13 @

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/17

Job Completion



mr
09-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

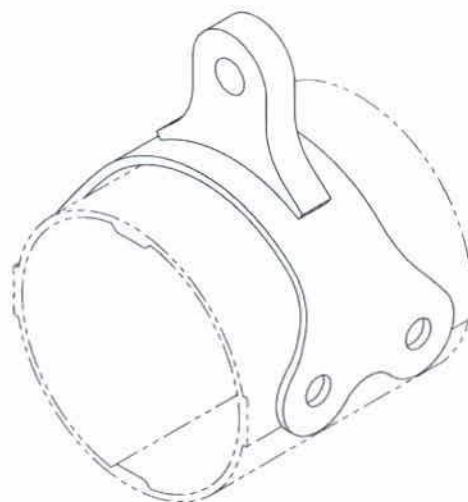
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

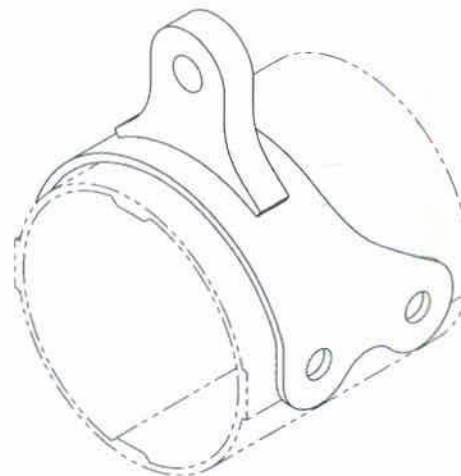
NOTE: Date & initial all entries

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△B



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

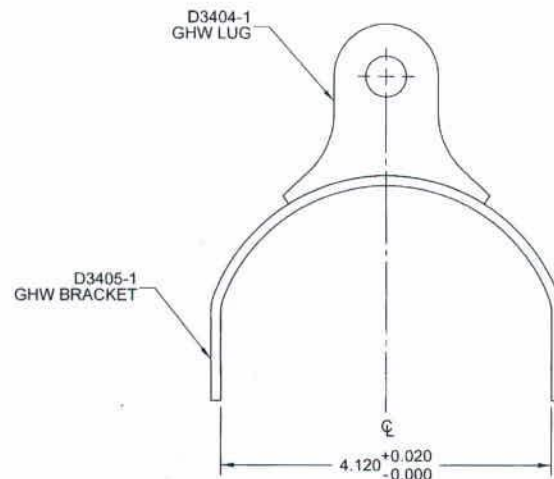
RELEASED
08/12/16

NO. 40071
WORK ORDER
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SUBJECT TO AMENDMENT
WITHOUT NOTICE

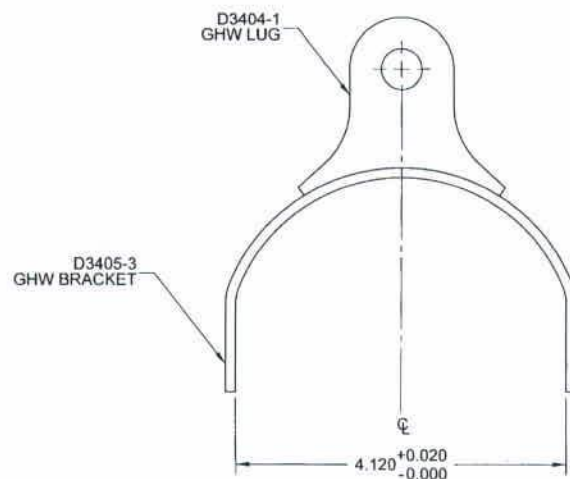
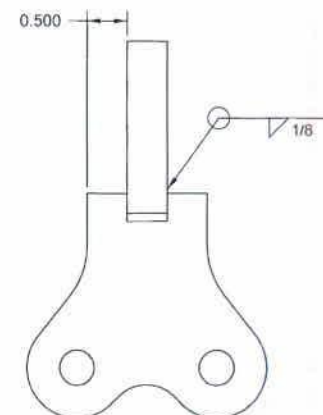
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

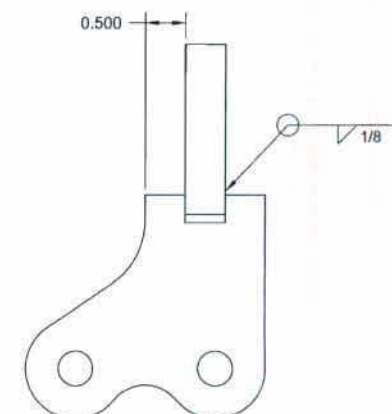
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4 120 DIM WAS 4.100		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3405 TITLE GHW LUG ASSEMBLY COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN	AJS			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.		REV. B	SHEET 1 OF 4	
DATE	08.09.19	SCALE	NTS	



D3405-041 LUG ASSEMBLY



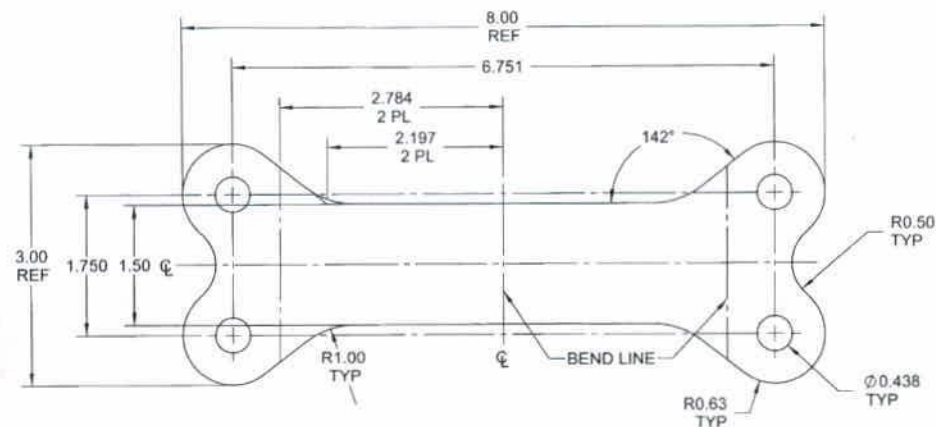
D3405-043 LUG ASSEMBLY



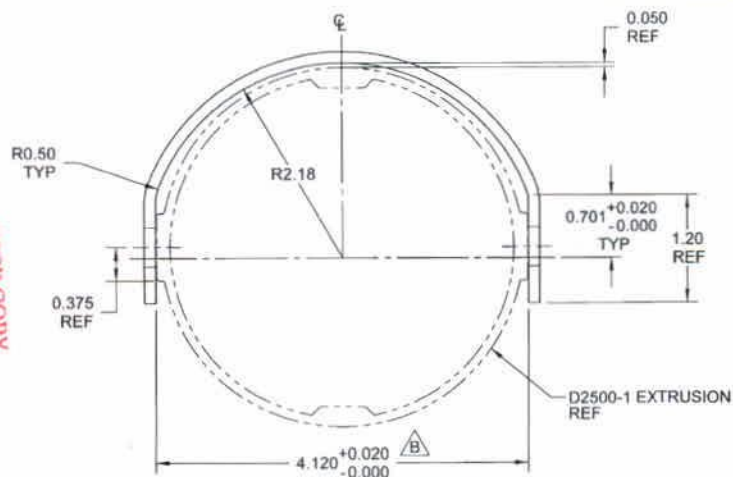
RELEASED
06/12/18

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 4
APPROVED		GHW LUG ASSEMBLY	SCALE NTS
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE LTD	
DATE	08.09.19	THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

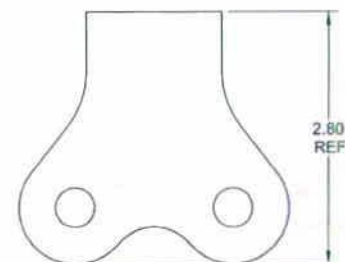
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46071



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46071

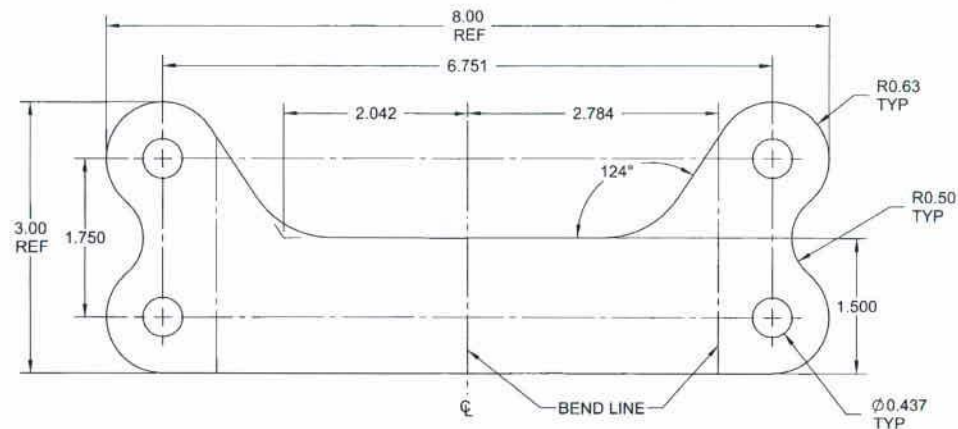
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

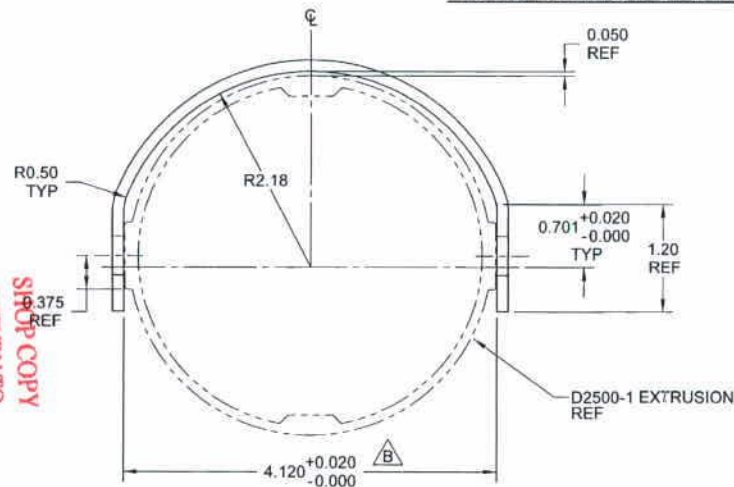
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

RELEASED
01/08/14

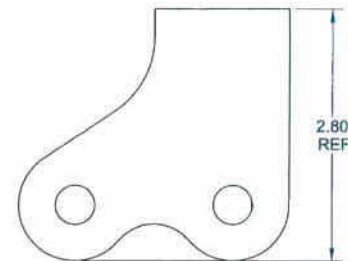
4
6.751
- 432
6.313



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NO. 11011
 WORK ORDER
 WITHOUT NOTICE
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

RELEASED

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A/S		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.		TITLE GHW LUG ASSEMBLY	SHEET 4 OF 4
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DATE	08.09.19	THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE (S) COVERED OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	